

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001879**Date Inspected:** 28-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Deck Panels		

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

QA inspector performed ultrasonic testing (UT) verification after ZPMC Quality Control (QC) UT inspections on partial penetration joints of the deck panel DP-067-001 to the U-Rib weld joints #1 thru #10. QC UT inspected 15% of the total weld length of each weld joint. ZPMC QC UT Inspectors found lack of penetration indications that results in depth of penetration less than the minimum of 9.6 mm required on weld joints for both deck panels. QA UT Inspector inspected 100% of required 15% QC UT inspection per weld joint. QA UT Inspector verified ZPMC QC UT findings. For details on UT inspections see modified TL-6027 UT Inspection report generated on this date

QA inspector performed ultrasonic testing (UT) verification after ZPMC Quality Control (QC) UT inspections on partial penetration joints of the deck panel DP-351-001 to the U-Rib weld joints #1 thru #10. QC UT inspected 15% of the total weld length of each weld joint. QA UT Inspection is 50% complete and will be completed for deck panel tomorrow. A modified TL-6027 UT report will be generated at the completion of the testing.

Summary of Conversations:

QA Inspector discussed with QC UT inspector Mr. Li Li Ming that when QC UT inspections are complete to ensure that a "QC UT complete" mark is placed on the deck panel inspected. Mr. Li Li Ming agreed and will mark on panel when UT inspection is complete.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowery, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Hager,Craig	QA Reviewer
